

Work Order ID 70415

Tuesday, June 07, 2011 1:39:55 PM



Page 1

Item ID: D4038-4

Accept



Setup Start



Revision ID:

Stop



Item Name: Angle, Aft, RH

Start Date: 6/7/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 6/21/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan: CL

Date: 11/06/09

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4038

E

100

0.00



Bandsaw

Memo

0.00

11/06/09

10

Jeaspa Bandsaw

Cut Blank 7.625" long

110

0.00



HAAS

Memo

0.00

CL 11/06/09 10

HAAS CNC vertical machine #1

Mill as per Dwg & Folio FA880

Dwg Rev:

Folio Rev:

Deburr

issue P10: 14260

Davis precision machine as per dwg
D 4038 REV.E

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Run Start



Stop



Sequence ID/
Work Center ID

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Description

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Run Hours

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Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120



QC
Quality Control

~~QC2~~ Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

rec'd + inspect for transit damage
attached c/c to w/o

Rec'd 6/7/11 (10)

130



QC
Quality Control

~~QC2~~ Inspect parts - second check

0.00

Memo

0.00

8/11/11

11 07 06 (10)

140



HandFinish
Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

10 11-7-7

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Customer:

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

10 of 11/07/07

160

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

Packaging

11/7/8 SP 100

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/7/11 SP
MF
11-07-08

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Page 1

Work Order ID: 70415

Parent Item: D4038-4

Parent Item Name: Angle, Aft, RH



Start Date: 6/7/2011

Required Date: 6/21/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: Ipp Rev:A New Issue 09-12-15 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6A4.000W.250		Purchased	No			100	f	15.5745	0.7	7.368421			
6061T6 ANGLE 4.00 x 4.00 x .250													

Location	Loc Qty	Loc Code
MAT006	14.29	
117285	14.29	
MAT007	1.2845	
114507	1.2845	

7.5 f # 11/06/09

D4038-4P

Rec'd 7/5 10

W/O:		WORK ORDER CHANGES					
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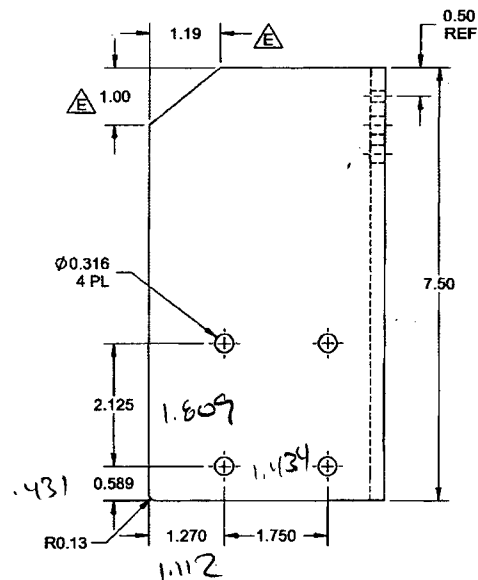
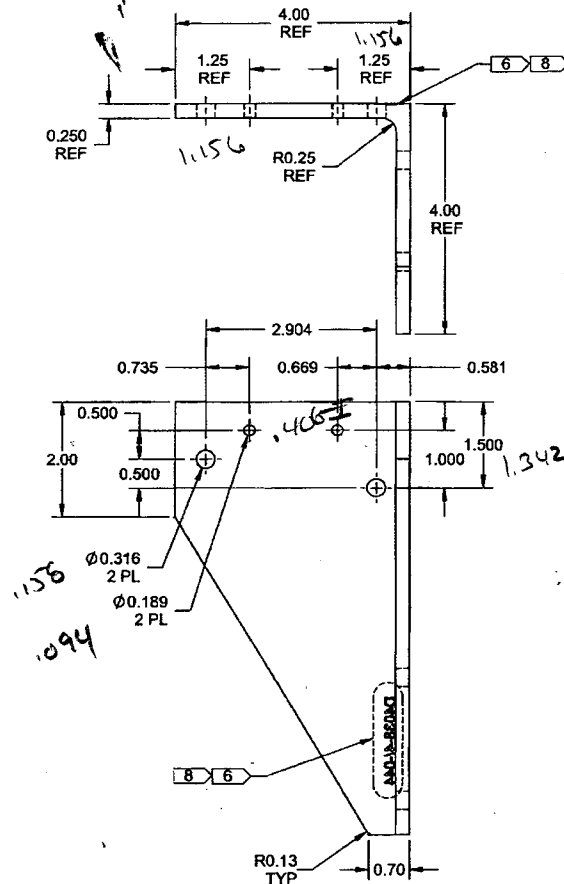
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CD 11106/07
WID: 70415



D4038-4 ANGLE, AFT, RH

NOTES:

- 1) MATERIAL: 6061-T6/T6510/T6511 ALUMINUM ANGLE, 4.000 X 4.000 X 0.250
PER AMS-QQ-A-200/8
REF DART SPEC M6061T6A4.000XW250
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N IN THIS AREA AS SHOWN (FAR SIDE ONLY) TO MAX
DEPTH OF 0.010 IN 0.18 HIGH LETTERS WITH MIN RADIUS TOOL OF 0.015
- 7) WEIGHT: 1.18 lbs
- 8) SPOT FACE MAX DEPTH OF 0.010 PRIOR TO MARKING

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D4038 REV. E
MFG. APPR.		SHEET 6 OF 14
APPROVED		TITLE BRACKET SCALE NTS
DE APPR.		
DATE	11.04.11	

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RELEASED
R 2011-04-21

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DAN'S PRECISION TOOLS INC.

2560 Devine Road, Vars, ON K0A3H0
Tel:(613) 835-3097 Fax:(613) 835-3760
support@dans-precision-tools.com

RE: CERTIFICATE OF COMPLIANCE

To:  PART AEROSPACE LTD.
1270 Aberdeen Street
Hawkesbury ON K6A-1K7
Tel: (613) 632-5200
Fax: (613) 632-5246

- We Certify that the part listed below meets the intent of the Purchase Order, and all applicable drawings and specifications.

Date : 04-Jul-11

 Purchase Order : PO14260

Packing Slip : 10537

Part Number : D4038-4revE

Quantity

10

8/10/11

Per: 

For Dan's Precision Tools Inc.